

Work Order ID 68121

Wednesday, April 06, 2011 3:46:33 PM

Page 1

Item ID: D4165-3

Accept

Revision ID:

Item Name: Inner Door Panel

Start Date: 4/7/2011 Start Qty: 2.00

Required Date: 4/8/2011 Req'd Qty: 2.00

Reference:

Cust Item ID:

Customer:

Setup Start

Stop

Run Start

Stop

Ship Friday
April 8th

Approvals: Process Plan: ME

Date: 11-04-06

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D4165

A

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg

Dwg Rev: 1

Prog Rev: 1

2-Deburr if necessary

B11-4-7

B

Pb →

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00


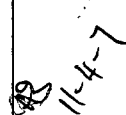
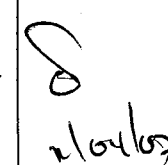
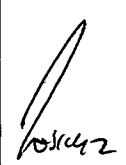

Quality Control

B11-4-7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D4165-3 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR: <u>68121</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
11/04/07	110	Qty x1 Part scrap Part got caught + Bent in the Deburring machine R.C. Process /		Scrap + Destroy no Re-line extra mase Qty x1	 11-4-7			

NOTE: Date & initial all entries

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Page 2

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Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

130

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

135

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

70 66

2 11-4-07

2 BK 11-4-7

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 68121

Page 3

Wednesday, April 06, 2011 3:46:33 PM

Item ID: D4165-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Inner Door Panel

Start Date: 4/7/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 4/8/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

11/4/11 20

150

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/4/11

MF
11-04-07

W/O:		WORK ORDER CHANGES						
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

Picklist Print

Wednesday, April 06, 2011 3:46:28 PM

Page 1

Work Order ID: 68121



Parent Item: D4165-3



Parent Item Name: Inner Door Panel

Start Date: 4/7/2011

Required Date: 4/8/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 11.03.09 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M2024T3S.040

Purchased

No

100

sf

130.5000

3.58

7.536842



FB11-4-7

2024-T3 .040 sheet

Location

Loc Qty

Loc Code

MAT022

130.5

112291

2.5

112331

64

113162

64

112331

13

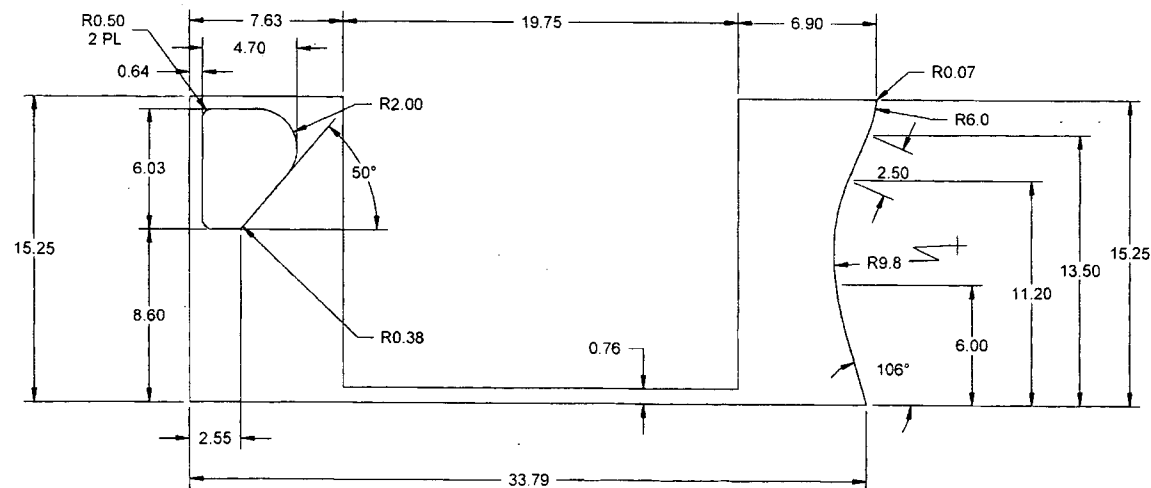
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NOTE: Date & initial all entries



D4165-3 INNER DOOR PANEL
(REF. EAGLE DRAWING No. D2046902 P/N EA20469-18)

NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.040 THICK
QQ-A-250/4 OR AMS-QQ-A-250/4
OR AMS 4037
OR ASTM B209
PER DART SPEC M2024T3S.040
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044.6.1
- 7) WEIGHT: 0.75 lbs

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO. D4165	REV. A
MFG. APPR.	RF	TITLE VRD PARTS	SHEET 2 OF 7
APPROVED	RF		SCALE
DE APPR.	RF		NTS
DATE	10.11.22	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PROPRIETARY AND CONFIDENTIAL. NO DISSEMINATION OR REPRODUCTION OF THIS DOCUMENT IS PERMITTED WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

#68121 RELEASED
2011-04-06
AM

W/O:		WORK ORDER CHANGES						
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